

Dart Aerospace Ltd. split Wednesday, 06/08/2008 9:20:01 AM Julie Lecocq **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : HELI-ACCESS STEP RH (FOLDING) Job Number : 40998 Estimate Number : 12568 P.O. Number Part Number : D412630034 This Issue : 06/08/2008 S.O. No. : **Drawing Number** : IIN D412-630 Prsht Rev. : NC Project Number : N/A First Issue : 06/08/2008 Type : LARGE FAB ASSY **Drawing Revision** Previous Run : 40269 Material : 28/08/2008 Written By **Due Date** Qty: Each Checked & Approved By Comment : Est. Rev:A New Issue 06-11-08 JLM ecn1019, added D2807-041 EC verified by:DD est rev B Additional Product Job Number: Seq. #: Machine Or Operation: Description: 1.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630 034 CHG003 2.0 D2012107 Clevis Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) S .8/11/13 (i Clevis Pick: Qty Batch

Part Number Description D2012-107 Clevis

3.0 D2803042

1

Bracket Assembly



Comment: Qty.:

1.0000 Each(s)/Unit Total: 5.0000 Each(s) **Bracket Assembly** 

Pick:

Part Number Qty D2803-042

Description

Bracket Assembly RH

Batch

D2804042



Comment: Qty.: 1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Pick:

Qty Part Number 1 D2804-042

**Bracket Assembly** 

Description Bracket Assembly RH Batch

**Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP RH (FOLDING) Job Number: 40998 Part Number: D412630034 Job Number: Seq. #: Machine Or Operation: Description: 5.0 D2807041 Gas Spring Assembly Comment: Qty.: 2.0000 Each(s)/Unit 35751 x2 185 08/111 Total: 10.0000 Each(s) Support Prop Batch: 58/08/07 (5 6.0 D2813 Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Washer 34020 x2 SS 98/11/13(x1) Pick: Qty Part Number Description Batch D2813 Washer 1020 7.0 D3562042 Step Assembly, RH Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description D3562-042 Step Weldment RH 8.0 D33951 Bushing Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s) 4035 X4 DS 08/11/13(X) Bushing Pick: Qty Part Number Description D3395-1 Bushing 9.0 AN3C21A BOLT Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) BOLT Pick:

Batch

Part Number

AN3C21A

Description

Bolt

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**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:

Seq. #:

Machine Or Operation:

Description:

10.0

AN8C16

Bolt

Comment: Qty.:

2.0000 Each(s)/Unit Total:

Part Number

**AN8C16** 

10.0000 Each(s)

M10599 12 B 08/11/13(41)

Bolt Pick:

Qty

Description Bolt

Batch

S/08/07 (55

11.0

2 AN310C8



Nut

Comment: Qty.:

2.0000 Each(s)/Unit Total:

10.0000 Each(s)

MIO6431 XZ NS 08/11/13 (XI)

Nut

Pick:

Qty Part Number AN310C8

Description

Nut

Batch

M166431

8 08/08/07/15

12.0

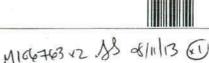
MS24665302

Cotter Pin



2.0000 Each(s)/Unit Total:

10.0000 Each(s)



Comment: Qty.: Cotter Pin

Pick:

Qty Part Number

Description

Cotter Pin (or AN380C3-4)

13.0

NAS1515H3

Washer



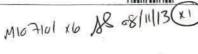
NAS1515H3

MS24665-302

Comment: Qty.:

6.0000 Each(s)/Unit Total: 30.0000 Each(s)

Washer



Pick:

Part Number Qtv

Description

Washer

14.0

NAS1515H5L

WASHER

Comment: Qty.: 4.0000 Each(s)/Unit Total:

20.0000 Each(s)

WASHER

Pick: Part Number

NAS1515H5L

Description

Washer

M108964+4 DS x1

S 08/08/04 1

## **Process Sheet**

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Washer

Description:

15.0

NAS1515H8

Comment: Qty.:

4.0000 Each(s)/Unit Total:

20.0000 Each(s)

MI66575 x 4 \$308/11/13 (3)

Washer

Pick:

Part Number Qty NAS1515H8

Description Washer

16.0

MS210433



Nut

Comment: Qty .:

4.0000 Each(s)/Unit

Total:

Screw (or MS24694-C565)

20.0000 Each(s)

Nut

Pick: Qty

Part Number MS21043-3

Description

Nut

Batch

08/08/07 (X5

17.0

MS24693C280





Comment: Qtv.:

Screw

Pick: Qty Part Number

Description

2.0000 Each(s)/Unit Total:

10.0000 Each(s)

M101390 FZ DS 08/11/15(+1)

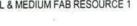
18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



MS24693-C280



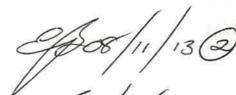


Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.14

> Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: H10992

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON



19.0

QC5

NSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



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## **Process Sheet**

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 40998

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Bushing

D28061

P35 630

Comment: Qty.:

2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Part Number

Description

Batch

D28063

D2806-1

Bushing

Bushing

B3653



Comment: Qty.:

2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

D2806-3

Part Number

Description Bushing

Batch

5 08/09/11

2 D28105

Strut

1.0000 Each(s)/Unit Total:



Comment: Qty.: Strut

Pick: Packing Kit

Part Number D2810-5

Description Strut

Batch

36521 XI

D33961

Spacer

B34025

Comment: Qty.: 10.0000 Each(s) 2.0000 Each(s)/Unit Total:

Spacer

Pick: Packing Kit

Part Number D3396-1

Description

Spacer

Batch

GC/calle (FS)

2 AN4C6A

6

Pick: Packing Kit

Part Number

5.0000 Each(s)

4107242



omment: Qty.: 1.0000 Each(s)/Unit

Bolt

Description

Total:

Batch

M16724



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Wednesday, 06/08/2008 9:20:01 AM Julie Lecoca **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HELI-ACCESS STEP RH (FOLDING) Job Number: 40998 Part Number: D412630034 Job Number: Seq. #: Machine Or Operation: Description: 31.0 NAS1515H5 Washer M10833 Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s) Washer Pick: Packing Kit Part Number Description Batch M 10 8334 NAS1515H5 Washer MS210434 32.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: Nut Pick: Packing Kit Part Number Description Batch M108672 MS21043-4 Nut MS210435 Fix this are pulled 9 to man Comment: Qty.: 3.0000 Each(s)/Unit 15.0000 Each(s) Total: Nut Pick: Packing Kit Qty Part Number Description 3 MS21043-5 Nut 34.0 QC4 KITS FOR COMPLETENESS Comment: INSPECT 100% KITS FOR COMPLETENESS 35.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-034 Location: PPP Rev 36.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion